

Date: Tuesday, 12/5/2006 7:57:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
 Job Number : 29743
 Estimate Number : 10552
 P.O. Number : N/A Part Number : D206642312
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 29742 Material : N/A
 Due Date : 1/10/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/
 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-312 CHG004

HAVE IN/MMS
07.02.20 KS. (1)

2.0 29743A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

D206-642-341 B 29743 A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2652 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BUSHING

Pick:

Qty	Part Number	Description	Batch
24	D2652	Bushing	B28693 3+
1	D206-642-341(REF)		B29007 21X

Batch

B28693 3+
29743A

B29007 21X

5.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description	Batch
			B28958

Batch

B28958

04/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2655 Tow Ring

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LUG ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
2	D2659	Lug Assembly	B29228 ✓

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty	Part Number	Description	Batch
10	D2712	Set Screw	B26481 ✓

8.0

D29322

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2932-2	Saddle	B30780 B29231 ✓

9.0

D29332

206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2933-2	Saddle	B29344 B29233 ✓

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2934	Saddle Spacer	B29345 ✓

CP 5463/201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description
2	D2935	Saddle Spacer

Batch

B29346 ✓

12.0

D29382

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2938-2	Saddle

Batch

B30281 B30481 ✓

13.0

D29392

206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2939-2	Saddle

Batch

B29349 B30301 ✓

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description
1	D2968-043	Tow Ring

Batch

B29353 ✓

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
4	AN3-37A	Bolt

Batch

M14478 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN3-41A	Bolt	M101938 ✓

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
1	AN4-5A	Bolt	M100857 ✓

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
12	AN4-6A	Bolt	M102959 ✓

19.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
4	AN5-10A	Bolt	M102083 ✓

20.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN5-11A	Bolt	M102658 ✓

CP 04/03/02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
4	AN5-12A	Bolt	M102380 (1X) ✓

M102658 (3X) ✓

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
12	AN960JD10	Washer	M100274 ✓

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
1	AN960JD1016	Washer	M5519 ✓

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
25	AN960JD416	Washer	M103338 ✓

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
8	AN960JD516	Washer	M102929 ✓

04/03/02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
1	AN970-4	Washer

Batch

1102929 ✓

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
12	MS21042L3	Nut

Batch

1102217 ✓

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
13	MS21042L4	Nut

Batch

1103349 ✓

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-312

Location: _____

PPP Rev: 0

10 7/3/5 ① 11/03/02 ① 11/03/05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 29743

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

SD 07103/06

Job Completion



u 07-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Tuesday, 12/5/2006 7:58:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 29743A
 Estimate Number : 10539
 P.O. Number : N/A Part Number : D206642341
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E
 Previous Run : 29742A Material : N/A
 Written By : Due Date : 1/10/2007 Qty: 1 Um: Each
 Checked & Approved By : JA 06 12 05
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG002

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2620 Bent Tube 3" OD B29388

JD 7-1-19

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2647 Fwd Cap M B24842 BE 07-01-24

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod MIDIDIO BE 07-01-24

4-Grind weld flush to cap on top surface only.

BE 07-01-24

JD 7-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end to length as per dwg D2650 *Pm 07-02-02(1)*

6-Drill pilot holes using drill Jig DT8168A (A, & B). Open to Ø0.312" *Pm 07-02-05(1)*

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". *Pm 07-02-05(1)*

8-Open Aft Cap Hole using #6 Drill Bit *Pm 07-02-05(1)*

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail *Pm 07-02-05(1)*

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650 *Pm 07-02-05(1)*

11-Deburr and Blow out all chips from inside the tube *Pm 07-02-05(1)*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 07-02-05

6.0

D26545

2061 Beam (Web)



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

B2979

Pm 07-02-06(1)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) *BE 07-02-06*

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid) *BE 07-02-06*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *BE 07-02-06*

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: *07-02-06* Time: *1:45 Pm*

Finish Date: *07-02-07* Time: *2am*

A/R Sikaflex-291

M62672

Sikaflex expiry date:

07-02-28

Pm 07-02-06(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-02-07

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

19 D2649

Crossbolt spacer

22329 BE 07-02-07

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M101010 BE 07-02-07*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube *Ph 07-02-08*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr *Ph 07-02-08*

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B24203 Ph 07-02-08

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M18548 Ph 07-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Monday, February 05, 2007 1:10 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: sikaflex-291

Jason,
Yes.
Bill

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 5, 2007 12:49 PM
To: 'Bill Beckett'
Subject: sikaflex-291

Bill,
We have 25 tubes of sikaflex-291, batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com
Q.C. COORDINATOR

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M1099

07-02-08 (1)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/02/14

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-02-13 (1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M-R/YL

07/02/21

(IX)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/22 (1)

19.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

29777

YL

07/02/22 (1)

20.0

D265611

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W/O:		WORK ORDER CHANGES					
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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2656-11 Wearshoe 16357

21.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe 29846

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe 29039

23.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B30237

07-02-28 (1)

24.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number Description Batch

54 ALS4-1032-130 Inserts M4102475
or (see QSI 017)

25.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number Description Batch

54 AN960JD10L Washer 102832

02/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:58:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS27039108

Screw



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 MS27039-1-08

Screw

101537

27.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs

29330

28.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings

29006

29.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

11151

30.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

6874

9/ 07/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:58:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap 30119

32.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer 102832

33.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw 100857

yl 07/02/23

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

102672

Sikaflex expiry date:

02/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

102672

Sikaflex expiry date:

02/07

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M103480

m. h. 07-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:58:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 29743A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20703-01



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

36.0

QC5

INSPECT WORK TO CURRENT STEP



20703-01



Comment: INSPECT WORK TO CURRENT STEP

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP

D206-642-312 B 29743 12/13/06

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20703/06

Job Completion



U 20703-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES SCALE NTS	
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
16 04 17 *PH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

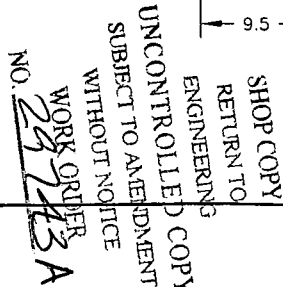
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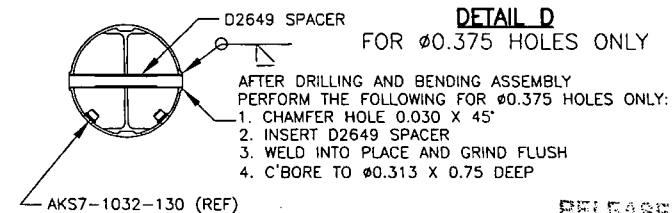
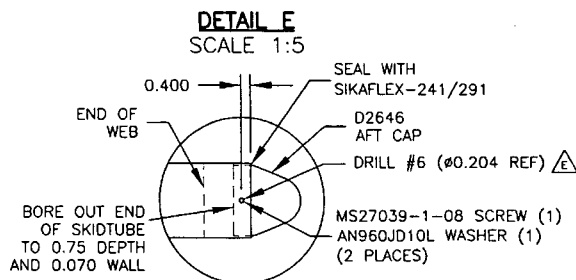
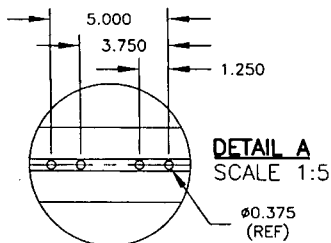
- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29743A

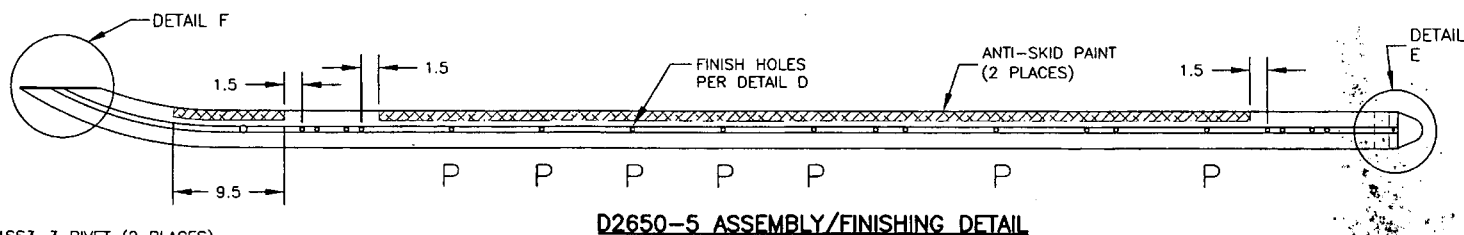
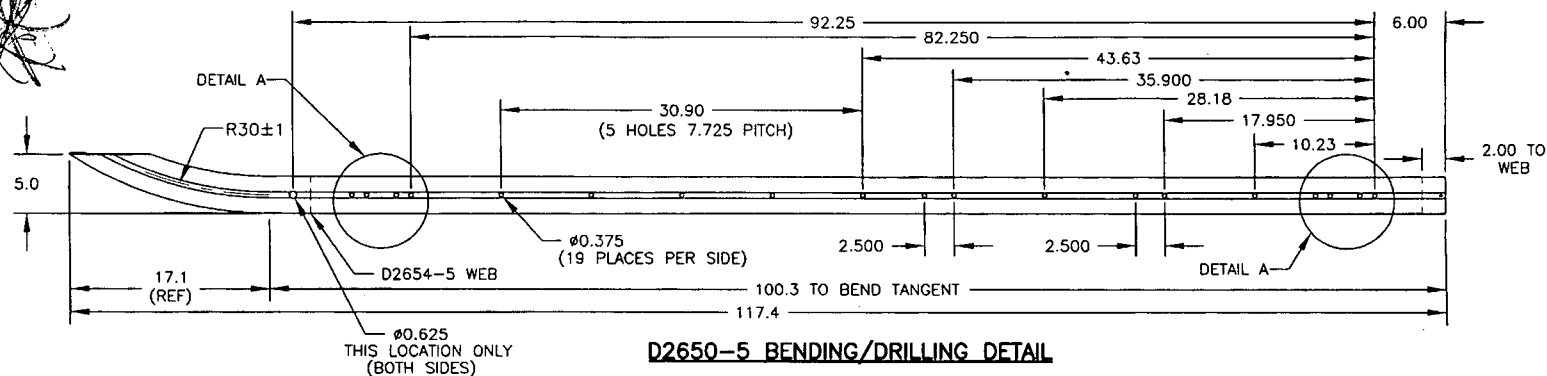
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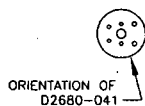
RELEASED



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

NO. 23743 A
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CHECKED	PH	APPROVED		DRAWING NO.	REV. E
DATE	06.03.30			D2650	SHEET 4 OF 5
				TITLE	SCALE
				SKIDTUBE	1:10

RELEASED
a.v.19 #

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Monday, February 05, 2007 1:10 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: sikaflex-291

Jason,
Yes.
Bill

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 5, 2007 12:49 PM
To: 'Bill Beckett'
Subject: sikaflex-291

Bill,
We have 25 tubes of sikaflex-291, batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com
Q.C. COORDINATOR

NO. 93

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number D206042341/B21744 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	<input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	<input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	<input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	<input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/12/07 Qualifier David David